

10/597495  
2-26-09

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property  
Organization  
International Bureau



(43) International Publication Date  
18 August 2005 (18.08.2005)

PCT

(10) International Publication Number  
**WO 2005/075122 A1**

(51) International Patent Classification<sup>7</sup>: **B21D 22/00**,  
B23P 15/14, B21K 1/30, B21D 53/26

(21) International Application Number:  
PCT/US2005/002625

(22) International Filing Date: 31 January 2005 (31.01.2005)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:  
10/769,740 30 January 2004 (30.01.2004) US

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(81) Designated States (*unless otherwise indicated, for every  
kind of national protection available*): AE, AG, AL, AM,  
AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN,  
CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI,  
GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE,

KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD,  
MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG,  
PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SY, TJ, TM,  
TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM,  
ZW.

(84) Designated States (*unless otherwise indicated, for every  
kind of regional protection available*): ARIPO (BW, GH,  
GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM,  
ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM),  
European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI,  
FR, GB, GR, HU, IE, IS, IT, LT, LU, MC, NL, PL, PT, RO,  
SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN,  
GQ, GW, ML, MR, NE, SN, TD, TG).

**Declaration under Rule 4.17:**

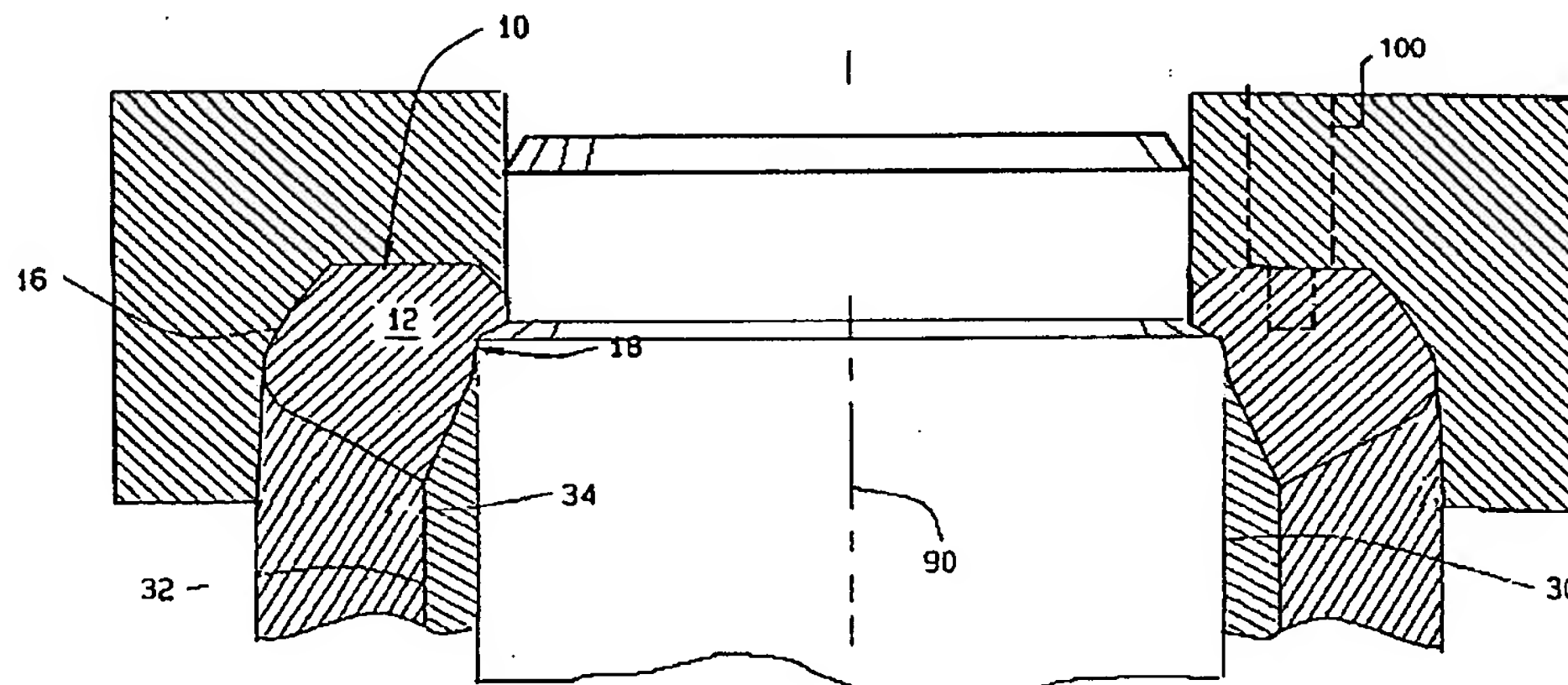
— *of inventorship (Rule 4.17(iv)) for US only*

**Published:**

— *with international search report*  
— *before the expiration of the time limit for amending the  
claims and to be republished in the event of receipt of  
amendments*

*For two-letter codes and other abbreviations, refer to the "Guid-  
ance Notes on Codes and Abbreviations" appearing at the begin-  
ning of each regular issue of the PCT Gazette.*

(54) Title: RING GEAR AND MANUFACTURING METHOD FOR SUCH A RING GEAR



(57) Abstract: A method of manufacturing a forged article (10) including a surface (18). The method includes defining a negative tooling pattern (52) based on the surface and providing a tooling set (28) having an anvil (30) and top (36) and bottom die (34). An upper surface (40) of the bottom die conforms to the negative tooling pattern. When the tooling is assembled the anvil extends through the bottom die and defines an axis. Additionally, the bottom and top dies cooperate to define a die cavity (76). A hollow blank (38) is preheated and placed on an anvil and into the die. In a single stroke, the hollow blank is pressed between the top and bottom dies in a pressing direction that is parallel to the axis. The preheating temperature  $T_w$  is a function of the homologous temperature ratio  $T_w/T_m$  is between .62 and .80, where  $T_m$  is the absolute melting temperature of the alloy.

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